

Work Order ID 124658

Thursday, September 18, 2014 3:01:01 PM

Item ID: 41228-202-150-001 Accept

Revision ID:

Item Name: Vent Valve Bracket

Start Date: 9/18/2014 Start Qty: 10.00 *10*

Required Date: 9/18/2014 Req'd Qty: 10.00 *10*

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____
QC: _____ Date: _____ SPC (Y/N): _____Sequence ID/
Work Center ID Operation
Description Set Up/
Run H

130 QC8- Inspect parts - second check 0.00

130

QC

Memo

Quality Control

140 Bend as per dwg 0.00

140

Brake NC

Memo

Brake NC

150 QC5- Inspect part completeness to step on W/O 0.00

150

QC

Memo

Quality Control

Work Order ID 124658

Thursday, September 18, 2014 3:01:01 PM

124658

Page 1

Item ID: 41228-202-150-001 Accept

Revision ID:

Item Name: Vent Valve Bracket

Start Date: 9/18/2014 Start Qty: 10.00 *10*

Required Date: 9/18/2014 Req'd Qty: 10.00 *10*

Reference:

N9000040100 Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: 4-09-18 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID Operation
Description Set Up/
Run Hours Tool ID Tool # Plan
Code Accept Reject Reject
Qty Qty Number Insp.
Stamp

Draw Nbr Revision Nbr

41228-202-150 IR

110

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: 12Prog Rev: 12

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

120

QC

Memo

Quality Control

SCRAP

Now D-Print
Part changed
DS184-1

scrap parts

DAS
30
9-89

14/10/12

Thursday, September 18, 2014 3:01:01 PM

1 24658

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Vent Valve Bracket

Start Date: 9/18/2014 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 9/18/2014 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

160

0.00

160

0.00

Outsource4

Memo

Outsource process - Anodize

ISSUE P/O ATG: _____
ANODIZE DYED RED AS PER DWG
(MIL-A-8625 TYPE II CLASS 2)

170

Receive & Inspect for Damage & Mat'l Certs

0.00

170

0.00

Packaging

Memo

Packaging

QC5- Inspect part completeness to step on W/O

0.00

180

0.00

QC

Memo

Quality Control

Work Order ID 124658

Thursday, September 18, 2014 3:01:01 PM

124658

Page 4

Item ID: 41228-202-150-001

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vent Valve Bracket

Start Date: 9/18/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/18/2014 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21 - Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

~~⊙~~
SCRAP
10-11-12

Picklist Print

Page 1

Thursday, September 18, 2014 3:01:04 PM

Work Order ID: 124658

124658

Parent Item: 41228-202-150-001

41228-202-150-001

Parent Item Name: Vent Valve Bracket

Start Date: 9/18/2014

Required Date: 9/18/2014

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.08.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.090		Purchased		No			sf	68.4000		2			

M2024T3S 090

2024-T3 .090 sheet

B.7

Location

Loc Qty

Loc Code

MAT022

68.4

123287

20.4

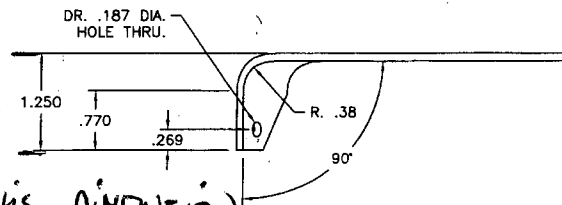
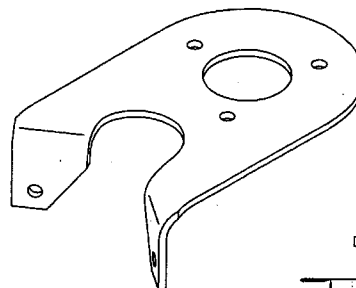
m130387

48

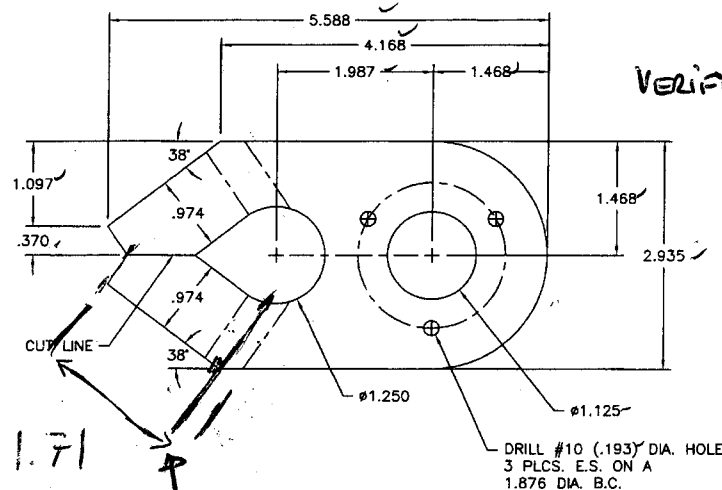
2.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1241058 MLJ

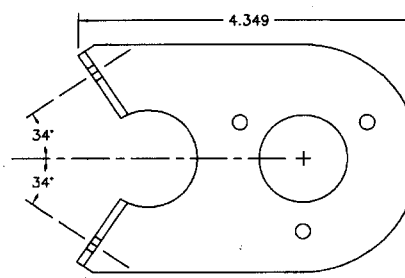
14-09-18



✓
VERIFY THIS DIMENSION



Verify this dimension



SHOWN BENT

-001 BRACKET

⚠ ANODIZE IN ACCORDANCE WITH MIL-A-8625 TYPE II CLASS 2, DYED RED.

NOTE:

-001		BRACKET		10 x 2.94 x 5.39		2024-T3 ALUM.			
PART NO.		NAME		STOCK SIZE		MATERIAL		ZONE	
LIST OF MATERIAL									
NO. REQ'D PER ASSY		UNLESS OTHERWISE SPECIFIED		DRAFTSMAN		DATE		TITLE	
2		X4:1		D. NELSON		8/8/01		VENT VALVE BRACKET	
41228-200-006		X100:±.010		CHECK		PLUMER BERT-BIGGS-NE		3/28/02	
		ANGLES ±1/2°		STRESS					
				PREP.					
				ENGR.					
				HEAT TREAT					
				FINISH					
				Era Aviation, Inc.		DWG. NO.		REV.	
						41228-202-150		IR	